

Ship 04/06

Dart Aerospace Ltd.

Date: Tuesday, 03/06/2008 2:00:34 PM
User: Linda Lacelle

Process Sheet

split into
SB 08/06/03

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : MIRROR ARM

Job Number : 39681

Estimate Number : 10335

P.O. Number :

This Issue : 03/06/2008 S.O. No. :

Prsht Rev. : NC

First Issue : 1/1

Type : SMALL /MED FAB

Previous Run : 39431

Part Number : D2010104

Drawing Number : D2010 PRELIM

Project Number : N/A

Drawing Revision : PRELIM

Material :

Due Date : 04/06/2008

Qty: 10 Um: Each

Written By :

Checked & Approved By :

Comment :

: Est A 04.02.17 New issue KJ/JLM

Est Rev:B 08-05-27 as per ECN1195P DD verified by:EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304TR0500W049

304 RD Tube .500 x .049W



Comment: Qty.: 1.5750 f(s)/Unit Total : 15.7500 f(s)

Material: 304/316 SS tubing 0.500" Dia. x 0.049" wall

(M304TR0500W049)

Batch No:

7.875

M108215

SB 08/06/04

2.0

BRAKE NC

NC BRAKE



Comment: BRAKE NC

Punch per Dwg. D2010-104 and Spec Control Dwg D2727

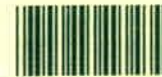
Identify as D2010-104

SB 08/06/04

3.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Bend as per Dwg D2010 using bending Jig D2010-104T2

2- Deburr ends

FF 08-06-04 (5)

4.0

D2057

Plug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Plug

batch: B39461

SB 08/06/04

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- flare before installing plug as per dwg D2010

FF 08-06-04 (5)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR ARM

Job Number: 39681

Part Number: D2010104

Job Number:



Seq. #:

Machine Or Operation:

Description :

2- Install D2057 plug as per Dwg D2010

FF 08-06-04 (5)

6.0

QC5

INSPECT WORK TO CURRENT STEP



08-06-04 (5)



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



M105642



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

9:25

OVEN TEMPERATURE:

320°

FINISH TIME:

9:55

FL 08/06/05 (5)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



Comment: INSPECT POWDER COAT

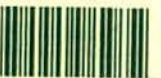
08-06-05

(X5)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST. 224

HL 08/06/05 (X5)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/06

Job Completion



U 08-06-06

1870

1871

1872

1873

1874

1875

1876

1877

1878

1879

1880

1881

1882

1883

1884

1885

1886

